
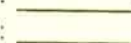


Date: Tuesday, 7/17/2007 1:59:23 PM
User: Kim Johnston

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 33579	
Estimate Number : 12576	
P.O. Number : N/A	Part Number : D3562041
This Issue : 7/17/2007 S.O. No. : N/A	Drawing Number : D3562 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : AC
Previous Run : 32719	Material : N/A
Written By : 	Due Date : 8/3/2007
Checked & Approved By : 	Qty: 5 Um: 6 Each
Comment : Est Rev:A New Issue 06-11-09 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Qty	Part #	Description	Batch:
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1	D2622-120C	Extrusion	B32858
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Check Material for any Dents or Defects

2.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B33861

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

4-Grind end cap welds flush as per Dwg D3562

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33579

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D3560041

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

ARM WELDMENT

9.0

D3560043

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

ARM WELDMENT

Batch: 334966

10.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 216.0000 Each(s)

Blind Rivet

batch: 1105125

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562.

Touch-up rivet holes with alodine as per dwg d3562

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnabond of the step

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33579

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Magnabond 6398

Batch: M104677

Q.R. 07.10.09

(5)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Q 07/10/09 (5041)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M103794

07.10.09 5

2-Grind end cap welds flush as per Dwg D3562

Q.R. 07.10.10

(5)

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07.10.10 5

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Q 07/10/10 (5041)

16.0

POWDER COATING

POWDER COATING



M105068



PTU

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 07/10/11

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M105674

FL 07/10/12

(5)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.5 ★ SEE W/D CHG

14 D2808-1 spacer B 32752

MF 07.10.10

Date: Tuesday, 11/17/2009 1:59:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33579

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

Sub 07/10/12 1

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/12 ①

Job Completion



U 07/10/12

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ONTARIO, CANADA

REV. C

DESIGN

CHECK

DRAWN BY *g*

DRAWING NO.

CHECKED 

APPROVED
211

7955

SCALE

DATE
07.06.19

SLEEP ASSEMBLY

NTS

A

06.09.26

NEW ISSUE

B

07.01.15

ARMS NOW RIVETED TO STEEL

5

07.06.19

NOW MAGBIND, ADD D2808, RMV 4 RVIS

07.06.29-~~11~~

07.06.27

-1.00

45.0'

- D2734 END PLATE
(TYP 2 PLACES)

TYPICAL STEP END DETAIL
NOT TO SCALE

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D3562-1,
MAKE FROM
EXTRUSION D2622

APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

D3560-043 ARM WELDMENT (FOR D3562-041, SHOWN)
OR D3560-044 ARM WELDMENT (FOR D3562-042, OPPOSITE)

02808

- D3560-041 ARM WELDMENT (FOR D3562-041, SHOWN)
OR D3560-042 ARM WELDMENT (FOR D3562-042, OPPOSITE)

- D2808 SPACER,
PRESS FIT AFTER POWDER COAT ON
OPPOSITE SIDE (2 PLACES)

REFER TO STEP
END DETAIL

- TRANSFER DRILL #30
INSTALL MS20600AD4W5
RIVET (32 PLACES),
DEBURR & TOUCH UP HOLES
WITH CHEMICAL CONVERSION
COAT BEFORE RIVETING

MEASURED BEFORE END CAPS WELDED IN PLACE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
FWD
WORK ORDER

D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

